

Date: Thursday, 7/20/2006 1:05:49 PM  
User: Linda Lacelle

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	27994		Part Number	D2573		
Estimate Number	10533		Drawing Number	D2573 REV E		
P.O. Number	N/A		Project Number	N/A		
This Issue	7/20/2006	S.O. No. : N/A	Drawing Revision	E		
Prsht Rev.	NC		Material	N/A		
First Issue	7/20/2006	Type : MACHINED PARTS	Due Date	8/5/2006		
Previous Run	27889		Qty:	16	Um:	Each
Written By						
Checked & Approved By						
Comment	Est: 1 As Per RevE 06-01-27 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101007	7075-T7351 8.25X7.75X2.5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B25354	J.G	06/09/01
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 27994 Double check by: SD		
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	ML	06/09/06
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	ML/5.G	06/09/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

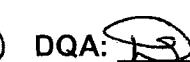
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: 

Date: 06/10/03

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Thursday, 7/20/2006 1:05:49 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27994

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/09/22 16

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAB 06/09/24 16

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06/10/02 X 16

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/09/02 (16)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: st 381

st 381

06/10/02 (16)

(16)

Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/03

Job Completion



06/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	27994
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.746	1.748	1.750		
C	3.495	3.505		3.496	3.496	3.500	3.500		
D	1.745	1.755		1.747	1.746	1.748	1.750		
E	7.990	8.010		8.001	8.005	8.006	8.004		
F	0.490	0.510		0.500	0.500	0.497	0.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.510	0.501	0.500	0.503		
J	1.174	1.184		1.177	1.176	1.177	1.179		
K	0.558	0.578		0.569	0.564	0.564	0.570		
L	1.174	1.184		1.177	1.176	1.177	1.179		
M	1.365	1.375		1.368	1.365	1.370	1.372		
N	2.495	2.505		2.500	2.497	2.495	2.499		
O	4.119	4.129		4.119	4.126	4.120	4.124		
P	0.115	0.135		0.119	0.123	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.241	0.242	0.243	0.244		
S	0.115	0.135		0.124	0.120	0.123	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.230	0.230	0.234		
W	0.115	0.135		0.115	0.117	0.121	0.120		
X	0.308	0.313		0.310	0.311	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.766	0.760		
Z	0.352	0.372		0.364	0.368	0.369	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.635	0.630	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.240	0.240	0.240	0.240		
AE	1.500	1.520		1.502	1.512	1.512	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.248	0.240	0.244		
AI	2.000	2.020		2.002	2.003	2.002	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G / Er/7w	Audited by:	M.S
Date:	06/09/06 / 06/09/07	Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	gut

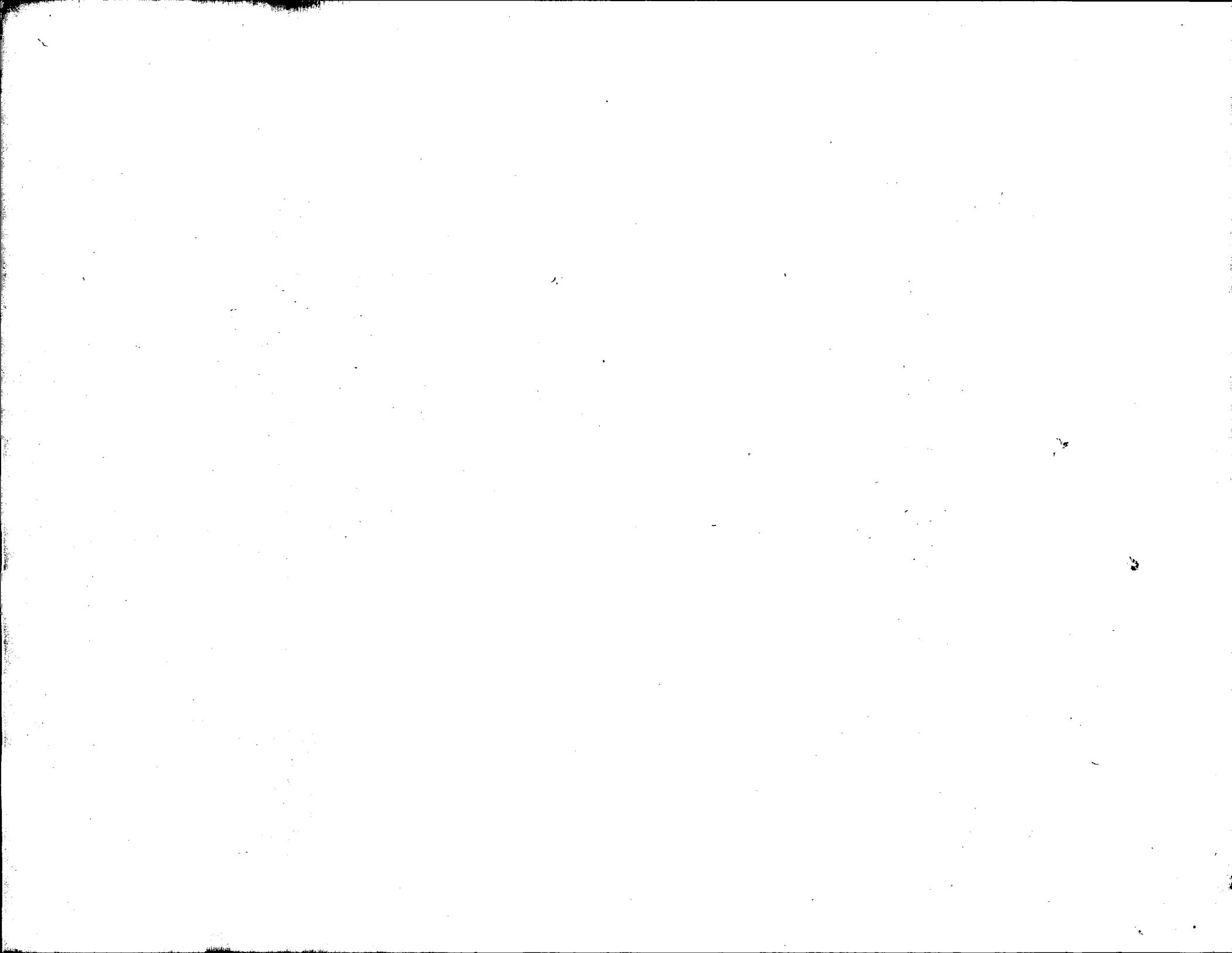
DART AEROSPACE LTD	Work Order:	27994
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	A 8		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.748	1.748	1.747		
C	3.495	3.505		3.499	3.500	3.495	3.498		
D	1.745	1.755		1.747	1.748	1.748	1.747		
E	7.990	8.010		8.004	8.005	8.004	8.004		
F	0.490	0.510		0.503	0.498	0.500	0.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.501	0.498	0.501	0.501		
J	1.174	1.184		1.178	1.175	1.176	1.176		
K	0.558	0.578		0.568	0.566	0.563	0.562		
L	1.174	1.184		1.178	1.175	1.176	1.176		
M	1.365	1.375		1.368	1.367	1.368	1.367		
N	2.495	2.505		2.500	2.500	2.495	2.496		
O	4.119	4.129		4.122	4.123	4.120	4.123		
P	0.115	0.135		0.123	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.254	0.254	0.254		
S	0.115	0.135		0.118	0.120	0.120	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.230	0.230	0.240	0.240		
W	0.115	0.135		0.122	0.123	0.123	0.118		
X	0.308	0.313		0.309	0.310	0.308	0.310		
Y	0.760	0.765		0.760	0.766	0.760	0.766		
Z	0.352	0.372		0.369	0.369	0.369	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.626	0.629	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.243	0.249	0.244		
AE	1.500	1.520		1.512	1.510	1.512	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.249	0.250	0.251		
AI	2.000	2.020		2.002	2.002	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>EP / TmL</i>	Audited by:	<i>MB</i>
Date:	<i>06/09/17</i>	Date:	<i>06/09/22</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DART AEROSPACE LTD				Work Order:	27994
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 1/2		
A	0.438	0.443	DT8682	—	—	—	—		
B	1.745	1.755		1.749	1.746	1.750	1.745		
C	3.495	3.505		3.501	3.500	3.498	3.499		
D	1.745	1.755		1.745	1.746	1.750	1.745		
E	7.990	8.010		8.006	8.004	8.005	8.004		
F	0.490	0.510		0.499	0.498	0.498	0.493		
G	0.257	0.262	DT8683	—	—	—	—		
H	0.375	0.380	DT8684	—	—	—	—		
I	0.490	0.510		0.499	0.499	0.499	0.501		
J	1.174	1.184		1.175	1.175	1.175	1.175		
K	0.558	0.578		0.564	0.563	0.565	0.564		
L	1.174	1.184		1.175	1.175	1.175	1.175		
M	1.365	1.375		1.368	1.368	1.369	1.367		
N	2.495	2.505		2.496	2.495	2.497	2.496		
O	4.119	4.129		4.124	4.122	4.121	4.119		
P	0.115	0.135		0.125	0.123	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.254	0.253		
S	0.115	0.135		0.118	0.120	0.121	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.238	0.237	0.239		
W	0.115	0.135		0.122	0.121	0.123	0.119		
X	0.308	0.313		0.316	0.308	0.310	0.316		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.367	0.368	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.632	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.246	0.249		
AE	1.500	1.520		1.570	1.571	1.573	1.571		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.251	0.246	0.244		
AI	2.000	2.020		2.000	2.001	2.003	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP	19m/	Audited by:	MS	06/09/22
Date:		06/07/17	Date:		

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SP/

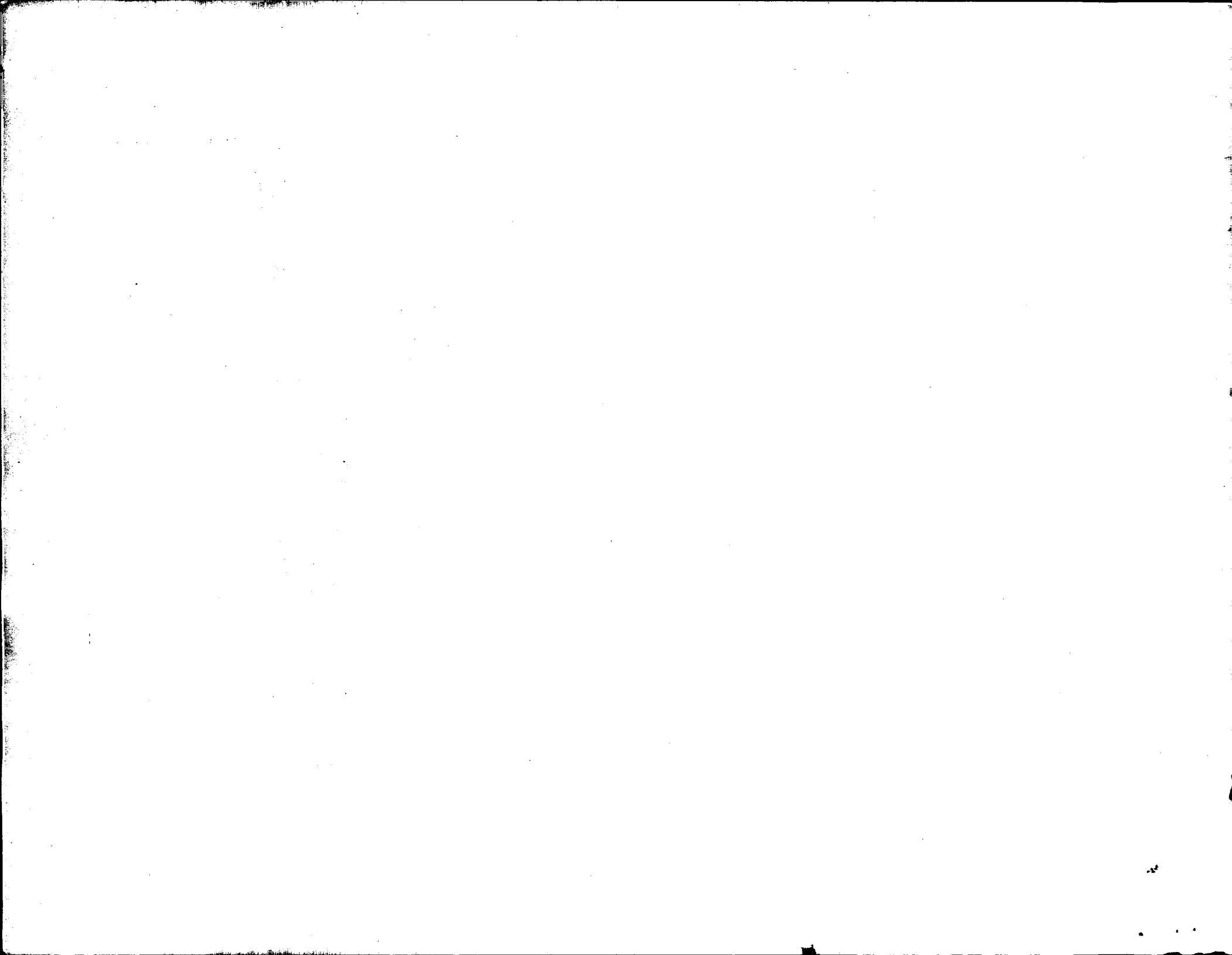
DART AEROSPACE LTD	Work Order:	27994
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 <sub>10</sub>		
A	0.438	0.443	DT8682	✓	—	—	—		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.506	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.006	8.005	8.005		
F	0.490	0.510		0.501	0.505	0.501	0.502		
G	0.257	0.262	DT8683	—	—	—	—		
H	0.375	0.380	DT8684	—	—	—	—		
I	0.490	0.510		0.504	0.502	0.502	0.502		
J	1.174	1.184		1.186	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.567	0.568		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.376	1.370	1.370		
N	2.495	2.505		2.500	2.506	2.500	2.500		
O	4.119	4.129		4.122	4.121	4.121	4.122		
P	0.115	0.135		0.123	0.123	0.122	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.255	0.253	0.254		
S	0.115	0.135		0.120	0.121	0.120	0.117		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.243	0.245	0.240	0.240		
W	0.115	0.135		0.121	0.121	0.120	0.119		
X	0.308	0.313		0.316	0.310	0.309	0.309		
Y	0.760	0.765		0.766	0.760	0.760	0.760		
Z	0.352	0.372		0.371	0.367	0.366	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.631	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.255	0.247	0.245		
AE	1.500	1.520		1.512	1.511	1.503	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.253	0.255	0.250	0.248		
AI	2.000	2.020		2.002	2.001	2.003	2.005		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

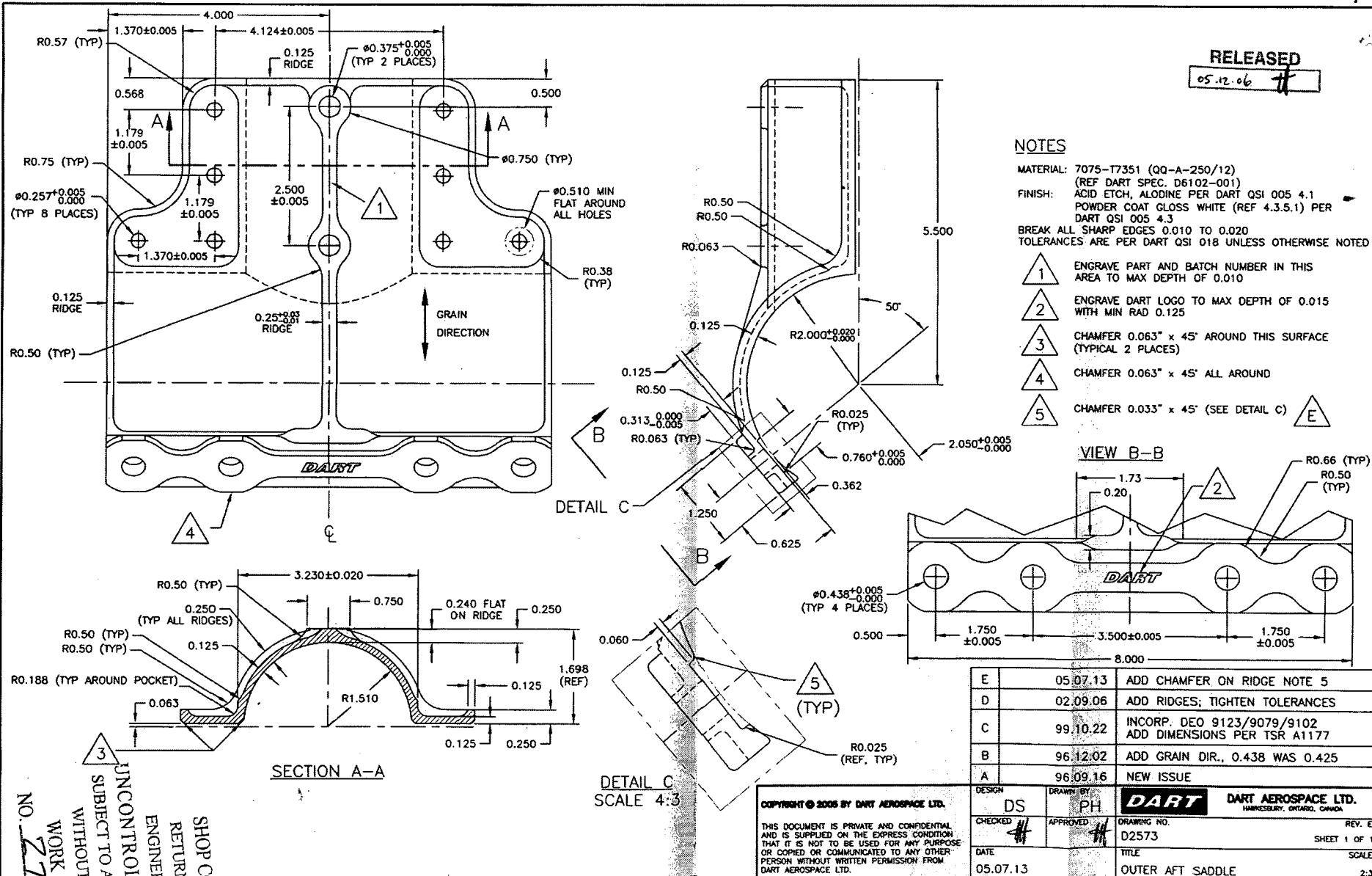
Measured by:	<i>SM</i>	Audited by:	<i>MS</i>
Date:	06/09/17	Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i>	<i>SM</i>



RELEASED

05.12.06 #



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 27994  
ENGINEERING WORK RETURN TO SHOP COPY